

DARTRELEASED
05-09-06

DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 	APPROVED 	DRAWING NO. D3274	REV. C SHEET 1 OF 4
DATE 05.03.16		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
9	9	D2648-3	WEARPAD
12	12	D2649	CROSS BOLT SPACER
1	1	D2656-15	WEARSHOE
1	1	D2656-23	WEARSHOE
1	1	D2656-35	WEARSHOE
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3287-1	WEARSHOE
1	1	D2646	AFT CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3429-1	WEARPAD
78	78	NAS1330C3KB116	INSERT
80	80	NAS1515H3L	WASHER
1	1	NAS1515H4	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
80	80	MS27039C1-08	SCREW
1	1	AN4C5A	BOLT

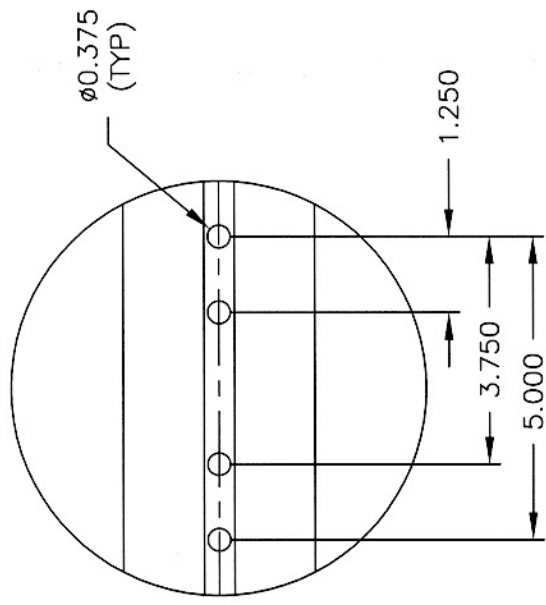
GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL 'E' (Ø0.250 REF) AND C'SINK Ø0.391x100° FOR NAS1330C3KB116 INSERT USING DT3274-1T2 BEFORE FINISH. INSTALL NAS1330C3KB116 INSERTS AFTER FINISH WITH LPS LABORATORIES "LPS-3".
8. WEARPLATES TO BE INSTALLED WITH A LAYER OF SIKAFLEX-241/-291 ADHESIVE BETWEEN WEARPLATES AND SKIDTUBE.
9. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DESGREASER.

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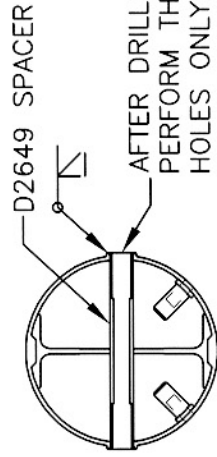
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DETAIL A: DRILL DETAIL



DETAIL B

FOR $\phi 0.375$ HOLES ONLY

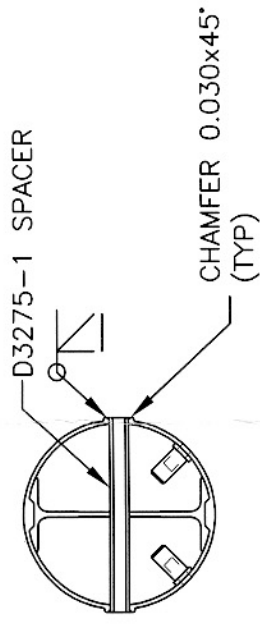


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR $\phi 0.375$
HOLES ONLY:

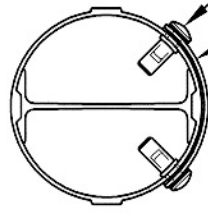
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO $\phi 0.313 \times 0.75$ DEEP

DETAIL C

FOR $\phi 0.313$ HOLES ONLY



DETAIL D



- NAS1330C3KB116 INSERT (1)
- MS27039C1-08 SCREW (1)
- NAS1515H3L WASHER (1)
- (78 PLACES)

WEARPAD/WEARSHOE (REF)

DETAIL E

- MS27039C1-08 SCREW (1)
- NAS1515H3L WASHER (1)
- (2 PLACES)

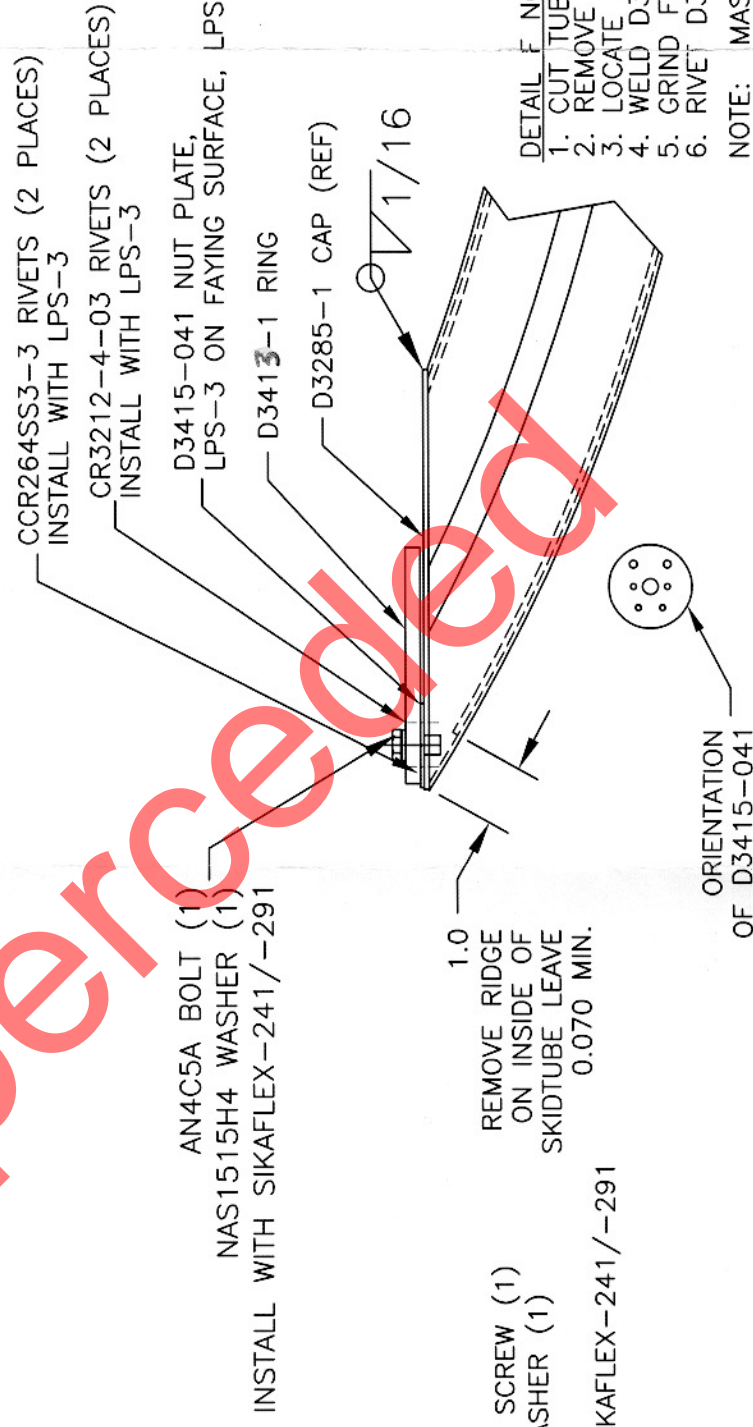
INSTALL WITH SIKAFLEX-241/-291

D2646 CAP
SEAL WITH
SIKAFLEX-241/291
ADHESIVE

$\phi 0.208$ (2 PLACES)
DRILL PRIOR TO INSTALLING
D2646 CAP

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

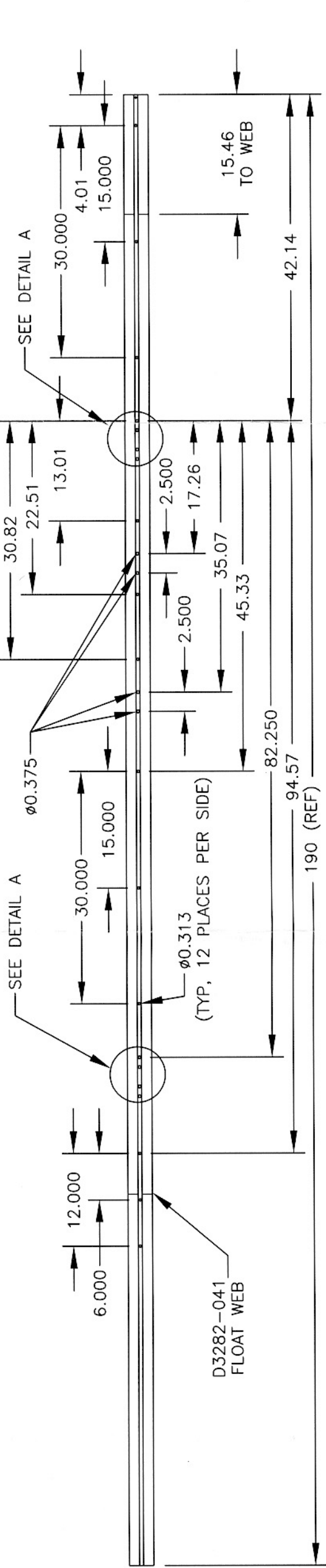
NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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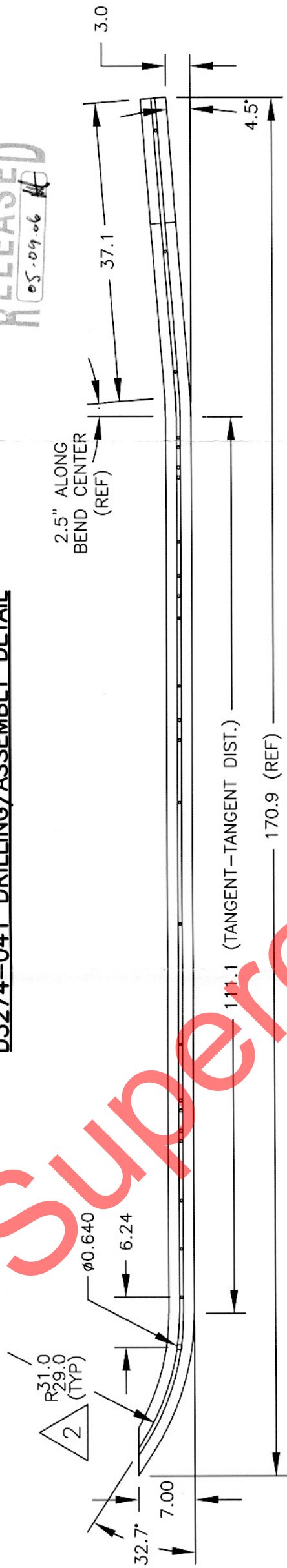
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CP	CP		PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE		D3274	SHEET 2 OF 4
05.03.16		TITLE	SCALE
		SKIDTUBE ASSEMBLY	1 TO 3

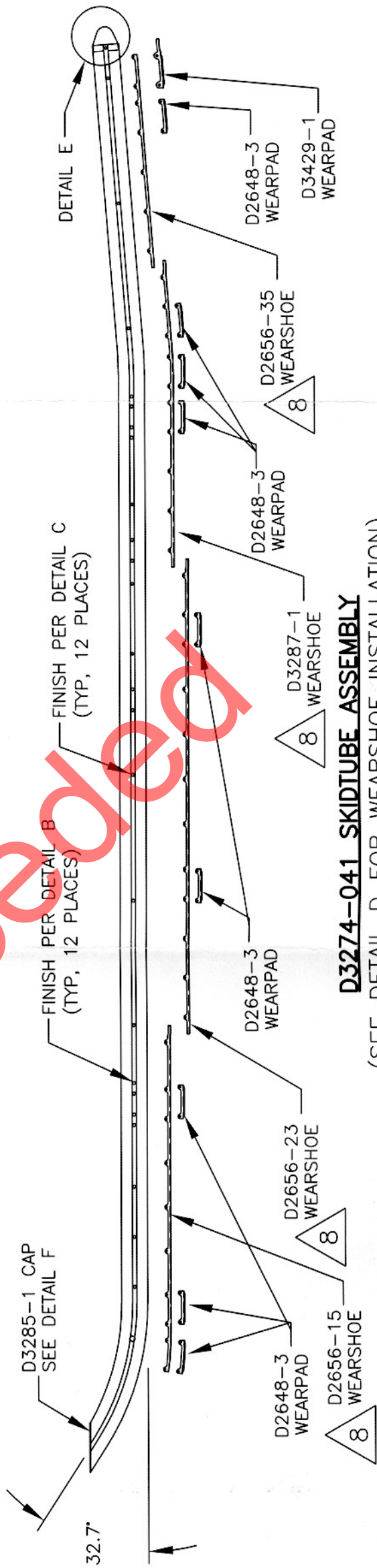


D3274-041 DRILLING/ASSEMBLY DETAIL

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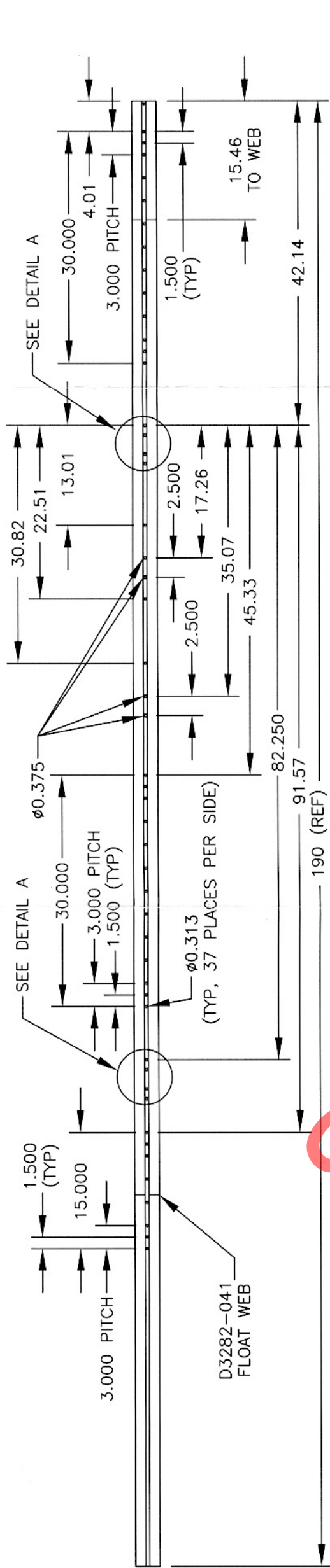
D3274-041 BEND/DRILLING DETAIL



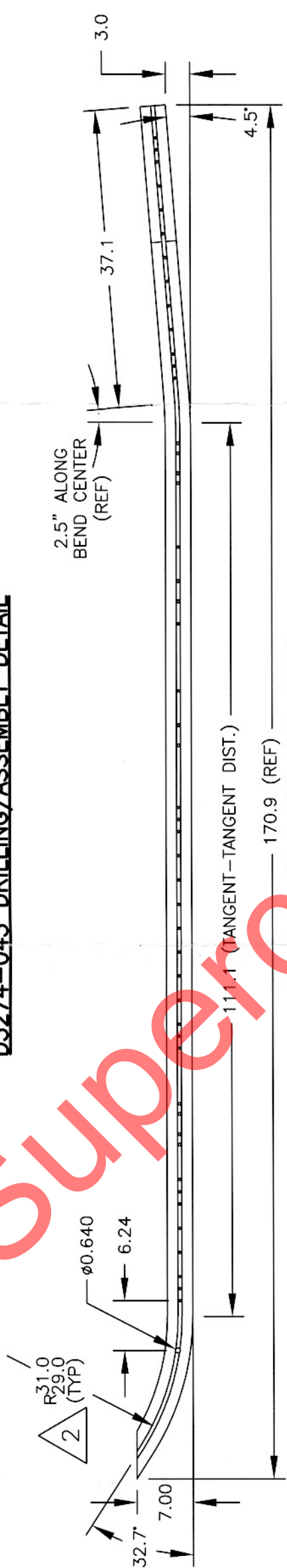
D3274-041 SKIDTUBE ASSEMBLY

(SEE DETAIL D FOR WEARSHOE INSTALLATION)

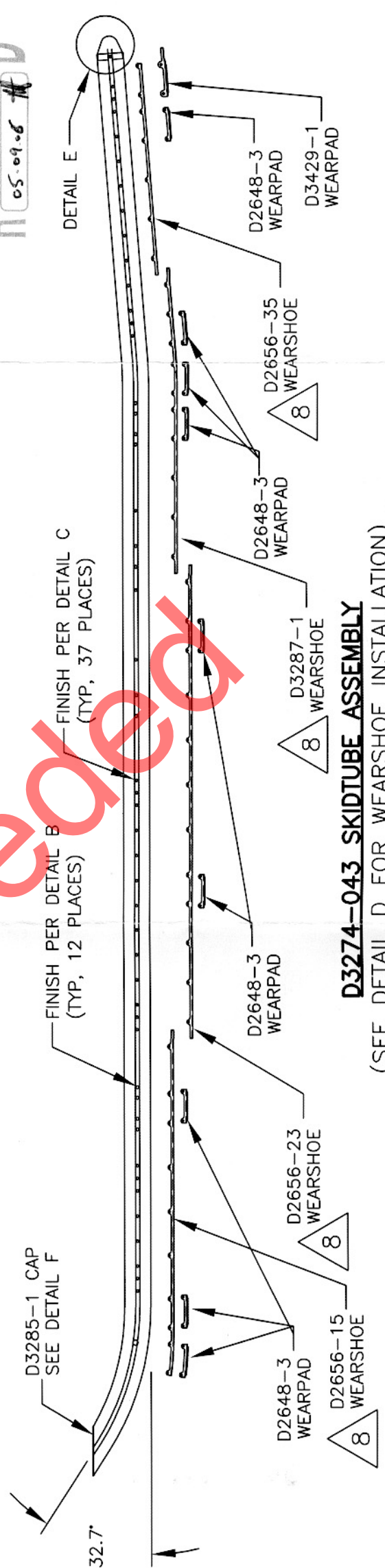
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		DATE	05.03.16			D3274	SHEET 3 OF 4
		TITLE	SKIDTUBE ASSEMBLY				
		SCALE	1:15				



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY (SEE DETAIL D FOR WEARSHOE INSTALLATION)

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CP	CP	4 OF 4	1:15
CHECKED	APPROVED	TITLE	
DATE	05.03.16	SKIDTUBE ASSEMBLY	